

Work Order ID 144560

April 21, 2016 9:16:14 AM

144560

BELL May 10th

Page 1

Item ID: D412-786-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tailboom Mount

Stop

NS2

Start Date: 4/25/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MCS Date: APR 21 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DAS

6

9-89

MAY 04 2016

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-786-025 chg001

2

DAS

27

9-89

MAY 11 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

DAS

6

9-89

MAY 04 2016

DAS

28

9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

2

DAS

27

9-89

MAY 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

April 21, 2016 9:16:14 AM

Page 2

Reference:

Stop ***NR2***

MAY 11 2016

M5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

April 21, 2016 9:16:18 AM

Page 1

Work Order ID: 144560

144560

Parent Item: D412-786-025

D412-786-025

Parent Item Name: Tailboom Mount

Start Date: 4/25/2016

Required Date: 5/10/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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NAS1149D0332J

Purchased

No

Each

1,480.000

24

48

NAS1149D0332.J

**

DAS

DAS

Washer

6
9-89

28
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

4

m133988

4

GA

88

m132677

88

ST260a

1000

m134502

1000

ST264

382

m133988

382

48

D4950-041

Manufactured

No

Each

5.0000

2

D4950-041

**

DAS

DAS

Tailboom Mount

6
9-89

28
9-89

Location

Loc Qty

Loc Code

ST139

5

111909

5

Each

0.0000

4

D4950-043

Manufactured

No

D4950-043

**

DAS

DAS

Tailboom Mount

6
9-89

28
9-89

144563

DAS
27
9-89

Picklist Print

April 21, 2016 9:16:18 AM

Page 2

Work Order ID: 144560

144560

Parent Item: D412-786-025

D412-786-025

Parent Item Name: Tailboom Mount

Start Date: 4/25/2016

Required Date: 5/10/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

Each

1,604.000

12 24

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

782

m133790

3

m134360

779

ST304

722

m134039

12

m134360

710

Each

183.0000

12 24

MS27039-1-11

Purchased

No

MS27039-1-11

Screw

Location

Loc Qty

Loc Code

GA

20

125654

13

9662

7

ST280

163

124326

163

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

MAY 05 2016

24

Page 1

[illegible]

Change Record

PAGE 1 OF 1

Part Number: D412-786-025Description: TAILBOOM MOUNT INSTALLATION[illegible]